

Work Order ID 114582

March-11-14 7:39:02 AM

114582

Page 1

Item ID: D4720-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacer

Start Date: 3/11/14

Start Qty: 600.00

600

Cust Item ID:

Required Date: 3/13/14

Req'd Qty: 600.00

600

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D4720	A

100

0.00

100

Hardinge

Hardinge CNC LATHE SMALL

Memo

0.00

Hardinge CNC Lathe Small

1- Machine as per Folio FB0

FOLIO REV:

DWG REV: A

FR 14/03/11

DO NOT CHAMFER OUTSIDE DIA

2- Deburr

210 Ø

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

FR 14/03/11

210 Ø

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Page 2

Item ID: D4720-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacer
 Start Date: 3/11/14 Start Qty: 600.00 ***600*** Cust Item ID:
 Required Date: 3/13/14 Req'd Qty: 600.00 ***600*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		14-3-11		210			DAS 13 2-83
130 *130* Outsource1 Outsource process - Heat Treat	Outsource process - Heat Treat Memo ***HEAT TREAT AS PER DWG D4720***	0.00 0.00		P/O: 23324					CL 14/03/12 210
140 *140* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.00				210x			SP 14-3-26

Push ASAP - Now!

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114582

Page 3

Item ID: D4720-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacer

Start Date: 3/11/14

Start Qty: 600.00

600

Cust Item ID:

Required Date: 3/13/14

Req'd Qty: 600.00

600

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC6- Inspect dimensions to drawing

0.00

DAS

27

9-89

150

QC

Memo

0.00

Quality Control

210

190

Identify as per dwg & Stock Location: LG001

0.00

190

Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

210 X

DAS

28

9-89

14-03-26

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MLJ

14-03-28

mf
14-3-27

Picklist Print

March-11-14 7:39:02 AM

Page 1

Work Order ID: 114582

114582

Parent Item: D4720-1

D4720-1

Parent Item Name: Spacer

Start Date: 3/11/14

Required Date: 3/13/14

Start Qty: 600.00

Required Qty: 600.00

Comments: IPP REV:A 12.11.20 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased			No	100	f	67.4824	0.265	168			

M6061T6T0.375W.058

**

6061-T6 RD Tube .375 x.058W

Location

Loc Qty

Loc Code

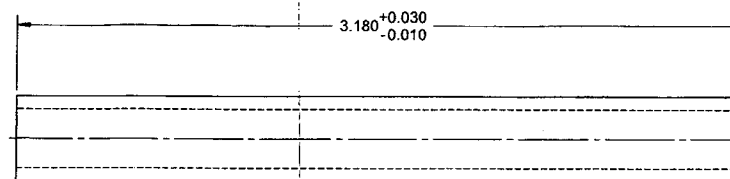
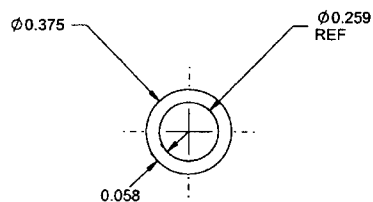
MAT014

67.482368

* m127600

67.482368

67.482368 ' FK 14/03/11



D4720-1 SPACER

NOTES:

- 1) MATERIAL: 6061-T4/T42 ALUMINUM TUBING PER WW-T-700/6, AMS 4081, OR ASTM B210 / B221 / B241
REF DART SPEC M6061T4T0.375W.058
OR
6061-T6/T62 ALUMINUM TUBING PER WW-T-700/6, QQ-A-200/8, QQ-A-225/8, AMS 4080 / 4082, OR ASTM B210 / B221 / B241
REF DART SPEC M6061T6T0.375W.58
HEAT TREAT TO -T4/T42 CONDITION. MIN UTS = 30 KSI (60 HREW MIN)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

A		NEW ISSUE		RP	12.09.10
REV.	DESCRIPTION			BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 1	
DRAWN	RP				
CHECKED		DRAWING NO.		SCALE	
MFG. APPR.		D4720		NTS	
APPROVED		TITLE			
DE APPR.		SPACER			
DATE	12.09.10			<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
194129	1	79943

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
23324		AL-6061	2014/3/13	FEDEX

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
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331 D4720-1
(121) D4720-1 SPACER
113686
(210) D4720-1
114582

1 BOITE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

EMPAQUETAGE Packing	
-------------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 331

POIDS EXPÉDIÉ / Weight Shipped : 6,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

2014-3-26

QUANTITÉ EXPÉDIÉE /Quantity Shipped: 331

POIDS EXPÉDIÉ / Weight Shipped : 6,00

Signature:

Date:



Metcor Inc.

560, boul. Arthur-Sauvé, St-Eustache (Québec) J7R 5A8

Tél. 450 473-1884

Télécopieur / Fax administration: 450 491-5498

Télécopieur / Fax production: 450 491-6454

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Rapport d'Inspection

Inspection Report

BON DE TRAVAIL order	CHARGEMENT load
194129	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
23324		AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

□

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	38 - 44 %IACS	66	37.0 - 38.0 %IACS
HARDNESS		66	64.5 - 68.0 HREW
			DURETÉE MESURÉE EN HR15TW = 65-67 HR15TW

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
331	6	D4720-1 (121) D4720-1 SPACER 113686 (210) D4720-1 114582 1 BOITE DE CARTON

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2014-03-24



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23324

Purchase Order Date 3/12/2014

PO Print Date 3/12/2014

Page Number 1 of 2

Order From :
METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

VC-MET004

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

F 6/11/103/12

Contact Name
Vendor Phone 450 473 1884

Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
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1	113686	D4720-1 SPACER	3/26/2014 Yes 3/26/2014		121.00 ✓	\$2.41	\$291.3
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HEAT TREAT TO T4/T42 CONDITION
MIN. UTS=30 KSI (60 HREW MIN)
NOTE: DETAIL C OF C REQUIRED

PART ARE MADE FROM 6061-T6 MATERIAL

Line Total: \$291.3

2	114582	D4720-1 SPACER	3/26/2014 Yes 3/26/2014		210.00 ✓	\$2.41	\$505.6
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HEAT TREAT TO T4/T42 CONDITION
MIN. UTS=30 KSI (60 HREW MIN)
NOTE: DETAIL C OF C REQUIRED

PART ARE MADE FROM 6061-T6 MATERIAL

8014-3-26

Line Total: \$505.6

Note:

3/12/2014